

Work Order ID 164090

164090

Page 1

Thursday, July 13, 2017 11:48:54 AM

Item ID: D3953-7

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Spring Spacer

Start Date: 8/2/2017 Start Qty: 12.00

12

Cust Item ID:

Required Date: 8/4/2017 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: 21 Date: JUL 13 2017

Tooling:

Date: _____

Run Start *NR1*

QC: 9-69

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3953	C

100

0.21

100

Hardinge

Memo

0.42

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA854 & DWG

FOLIO REV: AADWG REV: C

DEBURR

DAS

33

9-89

17/07/22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.12

Quality Control

DAS

33

9-89

17/07/22

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164090

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N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

120

QC

Memo

0.24

Quality Control

DAS

45

9-80

2017-7-23

Identify as per dwg & Stock Location: 5F069A 0.00

130

Packaging

Packaging

Memo

0.12

DAS
6
9-89

JUL 24 2017

QC21- Final Inspection - Work Order Release	0.00
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140

QC

Quality Control

Memo

1.20

**DAS
21
8-89**

JUN 24 2017

Picklist Print

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Work Order ID: 164090

164090

Parent Item: D3953-7

D3953-7

Parent Item Name: Spring Spacer

Start Date: 8/2/2017

Required Date: 8/4/2017

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDEL RINR0.750

Purchased

No

100

f

32.9620

0.05

0.631579

DAS

MDFI RINR0 750

33

9-89

Delrin Round Bar 0.75" color: black

17/07/22

Location

Loc Qty

Loc Code

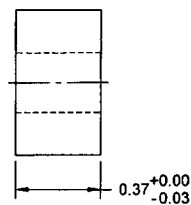
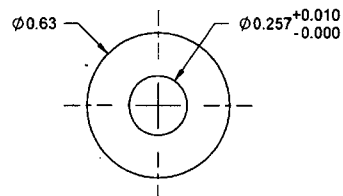
MAT018

32.962

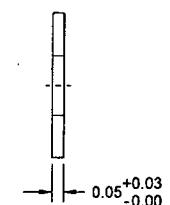
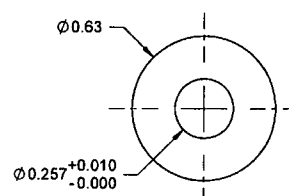
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32.962

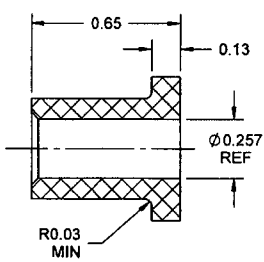
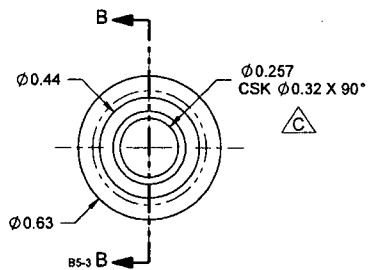
0.635



D3953-7 GAS SPRING SPACER

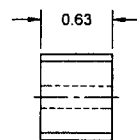
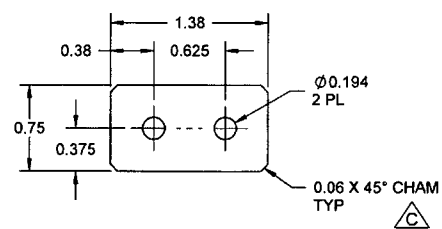


D3953-9 GAS SPRING WASHER



D3953-11 GAS SPRING SPACER

SECTION B-B B7-3



D3953-13 GAS SPRING SPACER

NOTES:

- 1) MATERIAL -7, -9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK
REF DART SPEC M-DELIN-R
- 13: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -7/-9/-11: < 0.01 lbs EACH
-13: 0.17 lbs

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

164090 ML
170713

RELEASED
2010-02-26

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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